

Work Order ID 74650 - 2



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Tuesday, October 04, 2011 3:23:48 PM

Item ID: D6101-003

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Billet, 7075

Start Date: 10/4/2011 Start Qty: 80.00

Cust Item ID:

Required Date: 10/10/2011 Req'd Qty: 80.00

Customer:

Reference:

Approvals: Process Plan:

Date: 11-10-4

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D6101

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 15091

a) Description: Aluminum billet

b) 7.875" x 6.250" x 2.00" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.875" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

11-10-4  
80

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

11/10/2011 10:00

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Page 2

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

*aml 11/10/26*

*60*

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6101

130

Identify as per dwg & Stock Location: *MAI47* 0.00

*aml 11/10/26*

*60*

Packaging

Memo

0.00

*60*

Packaging

140

QC21- Final Inspection - Work Order Release 0.00

*11/10/27*

QC

Memo

0.00

Quality Control

*mf 11-10-26*

# Picklist Print

Tuesday, October 04, 2011 3:23:54 PM

Page 1

Work Order ID: 74650

Parent Item: D6101-003

Parent Item Name: Saddle Billet, 7075





Start Date: 10/4/2011

Required Date: 10/10/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP A: 01.05.04 New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003P  7075-T7351 2X6.25X7.875		Purchased		No		110	Each	0.0000	1 	80			

*Rec'd 10/20/11 (59)*



**Castle Metals®**

A. M. Castle &amp; Co.

## PACKING SLIP

Page 1 of 1

Shipment No:1034473

<b>Ship From:</b> A. M. Castle & Co. (Canada) Inc. MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		<b>Sold To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		<b>Ship To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		<b>Deliver To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
<b>Date Shipped</b> 24-OCT-2011	<b>F.O.B.</b> ORIGIN	<b>Freight Terms</b> Prepaid		<b>Carrier</b> MANITOULIN		<b>BOL No</b> 1034473-2	

<b>Shipment Details</b>	<b>Final Destination Branch - MON</b>
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Order No	Line No	Item No	Description				
1765972	2	752237.MO	2.0000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT 2SIDED TO 6.25 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) X 7.875 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/12				
Purchase Order No		Part Number		Ordered Qty		Invoice Qty	
15091		YOUR ITEM NUMBER: D6101-003		59.00 PCS		59 PCS <i>600 pcs counted</i>	
Details							
Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
100322332		510182A9		59			599.49

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:      Name:

SHIP TO: A M CASTLE & CO 3050 SOUTH HYDRAULIC WICHITA, KS 67216
SOLD TO: AM CASTLE & CO- SOLD TO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4196201

CUSTOMER PO NUMBER: 55603	WORK PACKAGE:	CUSTOMER PART NUMBER: 6857 AMC A97075-160	SHIP RUN/LOAD: 101815/8	GOVT CONTRACT NUMBER:		
KAISER ORDER NO: 1099172	LINE ITEM: 3	SHIP DATE: 10-JUN-2010	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: Sawed Plate
WEIGHT SHIPPED: 2892 LB	QUANTITY: 2 PCS EST.	B/L NUMBER: 2027686	GAUGE: 2.0000 IN	DIAMETER/WIDTH: 48.500 IN	LENGTH: 144.500 IN	

### Certified Specifications

AMS 4078/RevG  
ASTM B 209/Rev07  
BSS 7055/RevA  
DPS 4.713/RevAH  
MMS 159/RevN

AMS-QQ-A-250/12  
ASTM B 594/Rev06  
CMMP 025/RevS  
GAMPS 9101/RevB  
PS 21211/RevK

AMS-STD-2154  
BAC 5439/RevH  
CSTI 006/RevC  
GSS16100/RevG/Amd1

Test Code: 4297

### Test Results

Lot: 510182A9 Cast 320

Drop 24

Ingot 4

(ASTM E8/B557)  
(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.8 : 74.3 (509 : 512)	63.2 : 63.6 (436 : 439)	12.4 : 12.8

(ASTM E1004)  
(EN 2004-1)  
Conductivity %IACS : 40.9 Min 41.0 Max  
(MS/M) : 23.7 Min 23.8 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.13	0.22	1.4	0.04	2.5	0.21	5.8	0.03	0.01	0.01	TOT 0.05



**KAISER  
ALUMINUM**

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

**CERTIFIED TEST REPORT**

Serial Number  
4196201

**ALLOY LIMITS**

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

**Aluminum Remainder****TEST NOTES**

7075-T7351 plate 3.501-4.000" thick, if  
ultrasonically inspected, meets requirements of CMMP025 per  
SDR CMMP025-KaiserT-3. 7075-T7351 plate 4.001-5.000" thick,  
if ultrasonically inspected, meets requirements of CMMP025  
per  
SDR CMMP025-KaiserT-2.

Metal represented by this test report was immersion  
ultrasonically tested from one side and meets the Class A  
and Class B requirements of all specifications referenced  
on this test report.

**CERTIFICATION**

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DFARS 225.872-11(a), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF DFARS 252.225 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTIRE ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED.

**BILL POYNOR, LABORATORIES SUPERVISOR**

*Bill Poy*

